



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-7
Job Sheet 173419



Part No: D3065-7

Job Qty: 60 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/9/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Waterjet		SC 18/03/05
100	Waterjet	60 pcs	3/8/18	3/8/18	0.00	2.21	Waterjet1		SC 18/03/05
120	QC	60 pcs	3/8/18	3/8/18	0.00	0.00	QC8		38
130	Small Fab	60 pcs	3/8/18	3/8/18	0.00	0.00			3-89
140	Brake NC	60 pcs	3/8/18	3/8/18	0.02	1.85	Brake NC 1		DAS
150	QC	60 pcs	3/8/18	3/8/18	0.00	0.00	QC5		38
160	HandFinish	60 pcs	3/9/18	3/9/18	0.00	1.06	HandFinish1		SA 18/03-12
170	QC	60 pcs	3/9/18	3/9/18	0.00	0.00	QC7-2		11
180	Packaging	60 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-1		GA 11/03/18
190	QC21-SA	60 Ea	3/9/18	3/9/18	0.00	0.00	QC21		GA 11/03/18

Part Op 100 - 1-Cut as per Dwg D3065
Descriptions: 130 - Deburr if necessary.
140 - Bend as per Dwg D3065
180 - LOCATION : GA

DAS
21
9-89

MAR 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	9.4440 sf (.1574 ea)	90-Start up Operation	

564221

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	9	88	0

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	

Container No: S047749
Part: D3065-7
Job No: 173419
Serial No/Batch: S047749
Revision: _____
Inspector: _____

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Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

☐ Finish
☐ Misread
☐ Turning Sequence
☐ Fit/Function
☐ Misaligned/off center

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.128inches + 0.005 - 0.000	0.133 0.128	0.129	
2	Step Spacer	0.865inches ± 0.005	0.870 0.860	0.865	
3	Step Spacer	4.522inches ± 0.010	4.532 4.512	4.521	
4	Step Spacer	0.250inches ± 0.010	0.260 0.240	0.250	
5	Step Spacer	2.093inches ± 0.010	2.103 2.083	2.092	
6	Step Spacer	3.936inches ± 0.005	3.941 3.931	3.937	
7	Step Spacer	4.186inches ± 0.010	4.196 4.176	4.187	
8	Step Spacer	1.250inches ± 0.005	1.255 1.245	1.250	
9	Step Spacer	0.125inches ± 0.010	0.135 0.115	0.125	
10	Step Spacer	Attribute			

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WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date: _____	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐	
OTHER: _____			